**AMENDMENTS TO THE CLAIMS:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

## Listing of Claims:

1.  (Currently Amended) Method for the operation of the rolling stands of a tandem cold rolling mill, comprising a pair of work rolls (10) and a pair of backup rolls (12) in the case of four-high rolling stands and, in addition, a pair of intermediate rolls (11) in the case of six-high rolling stands, wherein at least the work rolls (10) and the intermediate rolls (11) interact with axial shifting devices, comprising the combined use of the following technologies within the multiple-stand tandem cold rolling mill:

• use of CVC/CVC$^{plus}$ technology with CVC roll contours of higher order, wherein each work roll or intermediate ~~roll/intermediate~~ roll (10, 11) has a barrel lengthened by the amount of the shifting stroke;

• use of pair-cross (PC) technology, wherein each work roll or intermediate ~~roll/intermediate~~ roll (10, 11) can be swiveled parallel to the plane of the strip;

● use of strip edge-oriented shifting of the work <u>rolls</u> <u>or intermediate</u> ~~rolls/intermediate~~ rolls (10, 11), wherein each work <u>roll or intermediate</u> ~~roll/intermediate~~ roll (10, 11) has a barrel which is lengthened by the amount of the shifting stroke and which has a cylindrical or cambered cross section, and the work <u>rolls or intermediate</u> ~~rolls/intermediate~~ rolls (10, 11) are each symmetrically shifted from the ~~the~~ neutral shift position ($s_{ZW}$ = a or $s_{AW}$ = 0) by the same amount symmetrically to the center of the stand (Y-Y) in the direction of their axes of rotation (X-X).

2. (Currently Amended) Method in accordance with Claim 1, wherein, to use strip edge-oriented shifting, the work <u>rolls or intermediate</u> ~~rolls/intermediate~~ rolls (10, 11) are provided with a one-sided setback (d), such that when each work <u>roll or intermediate</u> ~~roll/intermediate~~ roll (10, 11) is shifted, the beginning ($d_0$) of the setback (d) is positioned outside the strip edge, at the strip edge, or inside the strip edge, i.e., within the width of the strip (14).

3. (Currently Amended) Method in accordance with Claim 1, wherein the shift position of the work <u>roll or intermediate</u> ~~roll/intermediate~~ roll (10, 11) in different strip width ranges

is predetermined by piecewise-linear step functions which are

based on different positions of the beginning ($d_0$) of the setback

(d) relative to the edge of the strip (14).


4.    (Previously presented) Method in accordance with Claim

1, wherein optimum utilization of the combination of technologies

within the multiple-stand tandem cold rolling mill is realized by

optimized shifting strategies as a function of the strip width.


5.    (Currently Amended) Tandem cold rolling mill,

comprising <u>four-high or six-high</u> ~~four-high/six-high~~ rolling

mills, each with a pair of work rolls (10) and a pair of backup

rolls (12) in the case of four-high rolling stands and, in

addition, a pair of intermediate rolls (11) in the case of six-

high rolling stands, wherein at least the work rolls (10) and the

intermediate rolls (11) interact with axial shifting devices,

wherein the work <u>rolls and intermediate</u> ~~rolls/intermediate~~ rolls

(10, 11) of the rolling stands each have a symmetrical barrel

which is lengthened by the amount of the shifting stroke, has a

cylindrical or cambered cross section, and is symmetrically

positioned in the center of the stand (Y-Y) for the neutral shift

position ($s_{ZW} = 0$ or $s_{AW} = 0$), <u>wherein suitable choice of the</u>

rolling stands allows a combination of the different technologies of

   • strip edge-oriented shifting of the work rolls and intermediate rolls (10, 11),

   • CVC technology, and

   • swiveling of the work rolls (10), PC (pair cross) technology within the multiple-stand tandem cold rolling mill.


6.    (Currently Amended) Tandem cold rolling mill in accordance with Claim 5, wherein the barrel of the work rolls and intermediate ~~rolls/intermediate~~ rolls (10, 11) is furnished with a one-sided setback (d), whose length (1) is divided into two adjacent regions (a) and (b), such that the first region (a), beginning with the radius ($R_0$), obeys the equation of the circle

   $(1 - x)^2 + y^2 = R^2,$

and the region (b) runs linearly, from which the following setback (d) or the following diameter reduction (2d) is obtained for these regions:

   Region a:

   $= (R^2 - (R - d)^2)^{1/2} \implies d = d(x) = R - (R^2 - (1 - x)^2)^{1/2}$

   Region b:

   $= 1 - a \implies d = d(x) = constant.$

7.    (Canceled)


8.    (Canceled)


9.    (Currently Amended) ~~Method~~ <u>Tandem cold rolling mill</u> in accordance with Claim <u>5</u> ~~8~~, wherein the CVC/CVC$^{plus}$ technology, the technology of strip edge-oriented shifting, and ~~possibly~~ PC technology are realized with only one geometrically identical set of rolls ~~by means of suitable plant conception~~.